

# Work Order ID 55464

January 19, 2010 9:50:05 AM



Page 1

Item ID: D3204-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 1/19/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *14*

Date: *10-1-19*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn tube as per Folio FA356 and Dwg D3204: 12-Debur

*CA 10/02/31*

*5 0*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*CA 10/02/31*

*5 0*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*M.A 10/02/01*

*5 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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January 19, 2010 9:50:05 AM

Page 2

Item ID: D3204-1

Accept

Revision ID:

Item Name: Tube

Start Date: 1/19/10 Start Qty: 4.00

Required Date: 1/25/10 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Rec'd 5

10/02/03  
MF 10-2-3

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# Picklist Print

January 19, 2010 9:50:09 AM

Page 1

Work Order ID: 55464



Parent Item: D3204-1



Parent Item Name: Tube

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP: 04.06.09 Change Step 6; remove Steps 7 & 8. KJ/RF

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.750W.125		Purchased	No			100	f	20.7200	2.1895			



6061-T6 RD Tube .750 x .125W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

20.72

111409

20.72

2.624 SA 10/0031

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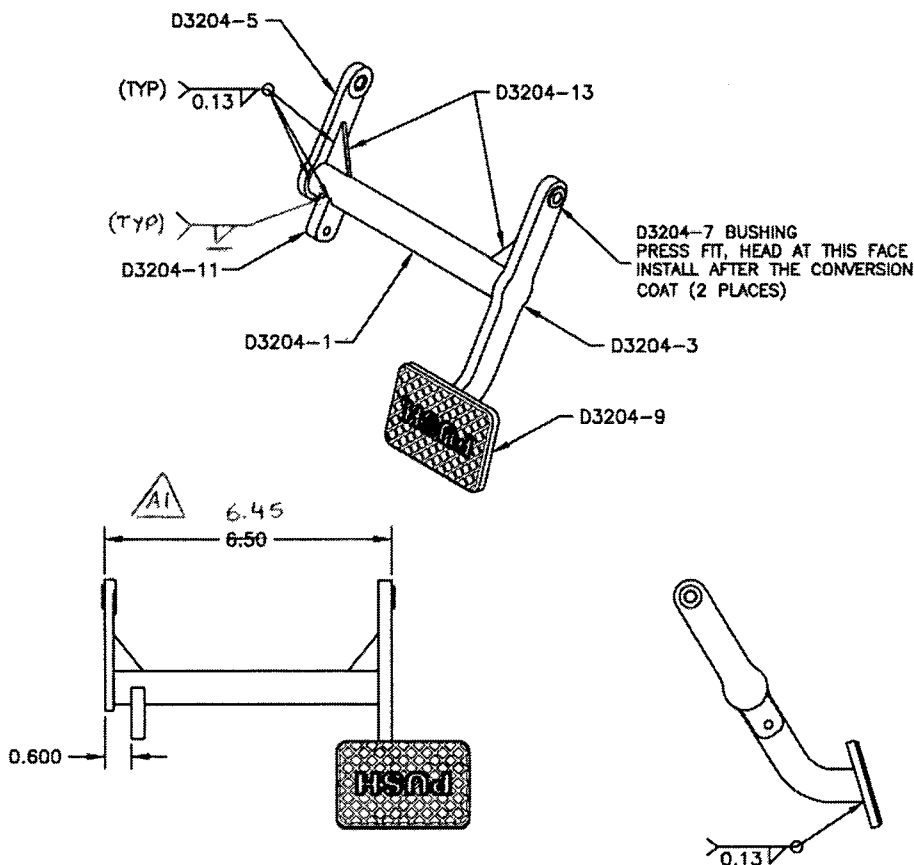
**NOTE:** Date & initial all entries



**DART**

DESIGN #	DRAWN BY #	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

**RELEASED**  
04.04.30



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35464

10-1-19

### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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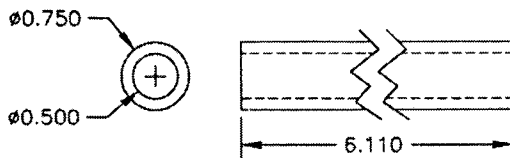
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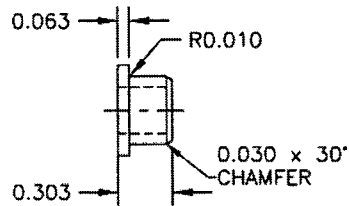
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**DART**

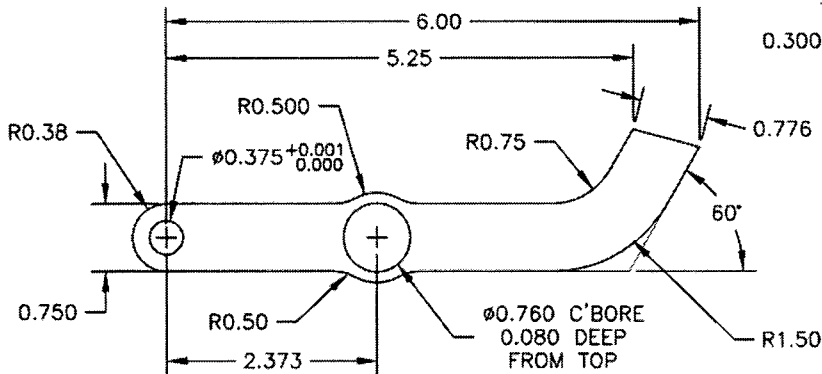
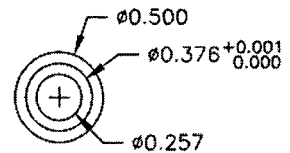
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CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

**RELEASED**  
04.04.05

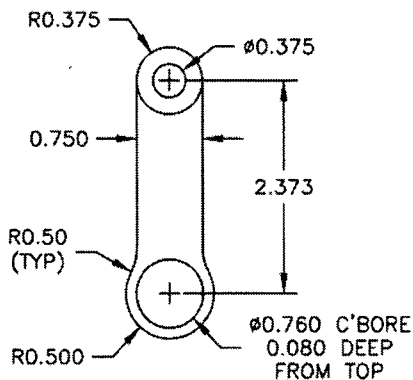
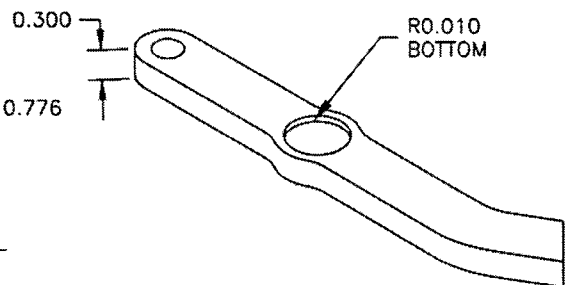
2 **D3204-1 TUBE**  
SCALE 1:2



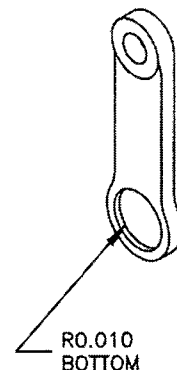
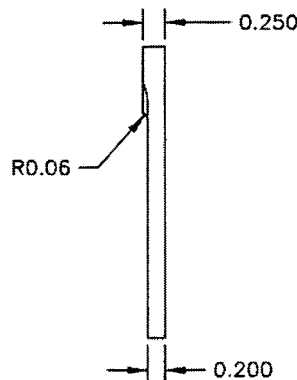
4 **D3204-7 BUSHING**  
SCALE 1:1



3 **D3204-3 ARM**  
SCALE 1:2



3 **D3204-5 ARM**  
SCALE 1:2



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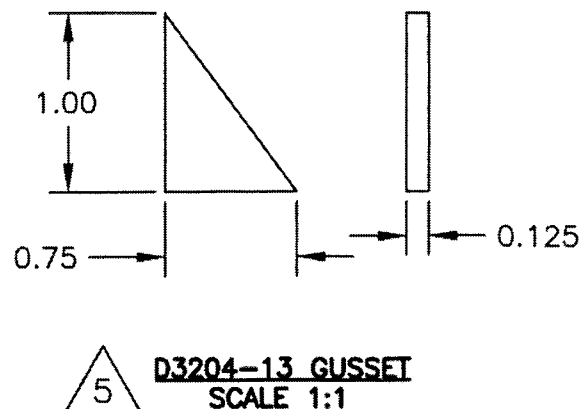
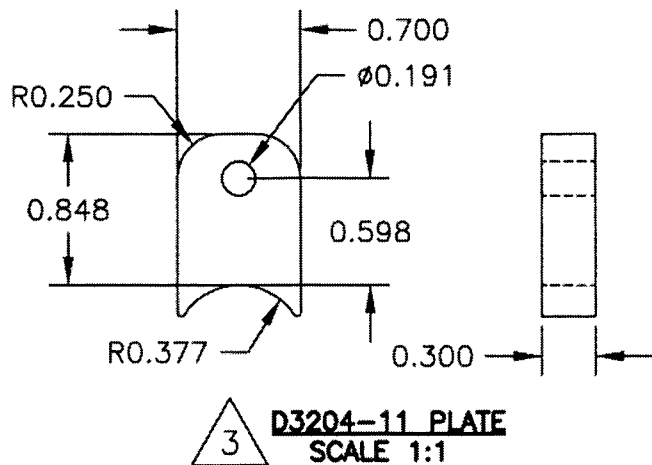
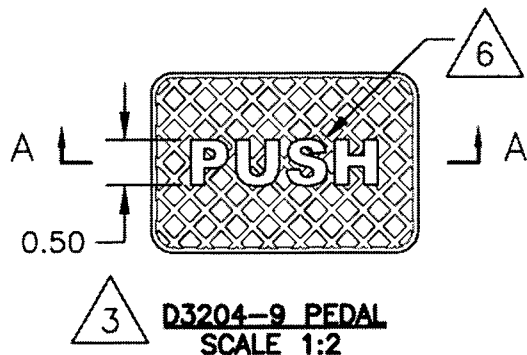
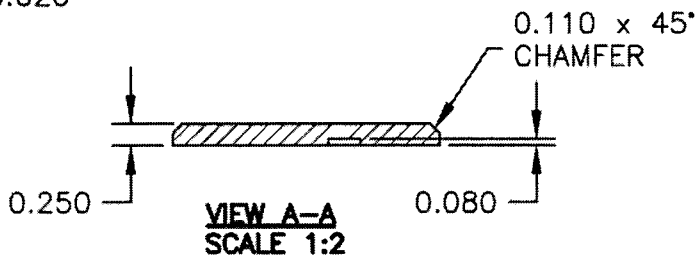
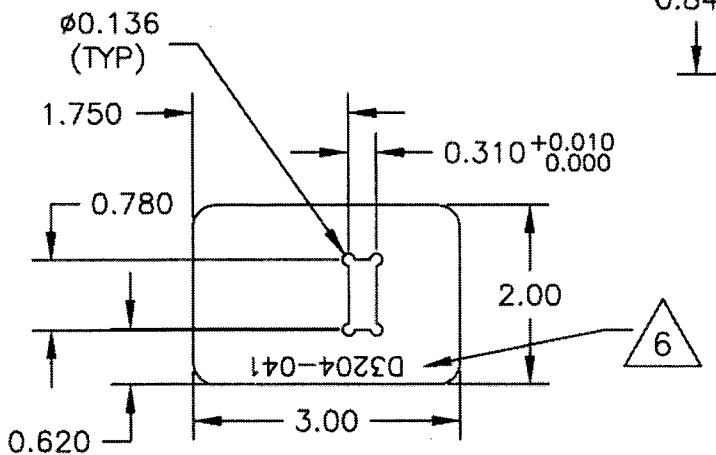
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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

W/D 53464

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04.04.30



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